

Work Order ID 91289

91289

Page 1

Thursday, November 15, 2012 1:29:28 PM

Item ID: 647.4610 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Deflector

Start Date: 10/4/2012 Start Qty: 15.00 ***15***
 Required Date: 10/4/2012 Req'd Qty: 15.00 ***15***
 Cust Item ID:
 Customer:

Reference: *Jan 12-11-17*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| 647.2600 | N/C |

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut Blank at 20.000"

SL 12-11-20 16

*****ONE BLANK MAKES TWO PARTS*****

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1

1-Machine per folio FB139
 DWG REV: *N/C*
 FOLIO REV: *AA*

Jan 12/11/21

16

DAS
14
2-89

2- deburr and break all sharp edges

Work Order ID 91289***91289***

Page 3

Thursday, November 15, 2012 1:29:28 PM

Item ID: 647.4610

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Deflector

Start Date: 10/4/2012 Start Qty: 15.00

15

Cust Item ID:

Required Date: 10/4/2012 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Receive & Inspect for Damage & Mat'l Certs | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 155 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *155* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 160 | Spray Painting per QSI005 4.2 | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| SprayPaint | Memo | 0.00 | | | | | | | |
| Spray Painting | PRIME AS PER DWG, SEE NOTE #2 | | | | | | | | |
| *** SEE NOT #5 FOR MAX. DIMENSION AFTER FINISH *** | | | | | | | | | |
| PRIMER BATCH: <u>123693</u> | | | | | | | | | |

01/21/18 (16)16DAS
05
9-89 13.01.0616DAS
05
9-89 13.01.07

Work Order ID 91289

91289

Page 4

Thursday, November 15, 2012 1:29:28 PM

Item ID: 647.4610 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Deflector
 Start Date: 10/4/2012 Start Qty: 15.00 *15* Cust Item ID:
 Required Date: 10/4/2012 Req'd Qty: 15.00 *15* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 *170* QC Quality Control | QC14- Inspect Spray Paint Memo | 0.00 0.00 | | | | (416) | | | |
| 180 *180* Packaging Packaging | Identify as per dwg & Stock Location: 1396 Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** | 0.00 0.00 | | | | | | | |
| 190 *190* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

ME
13-01-09

Picklist Print

November-16-12 10:30:54 AM

Page 1

Work Order ID: 91289
 Parent Item: 647.4610
 Parent Item Name: Upper Deflector

Start Date: 10/04/12 Required Date: 10/04/12
 Start Qty: 15.00 Required Qty: 15.00

Comments: IPP REV:A NEW ISSUE 12/10/17 JFS VERIFY BY: DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M7075T6B5.000X0.375 7075-T6 BAR 5.000" X 0.375" | | Purchased | No | | | | f | 99.1620 | | 12.6 | | SL 12-11-20 | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT | 51.162 | |
| 123218 | 51.162 | |
| MAT008 | 48 | |
| 123418 | 48 | |

~~34~~ 6.8
 * 6.8

1.6

19.7
 .84

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions |
| | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

| | |
|--|------------------------------|
| DART AEROSPACE LTD | Work Order: 91289 |
| Description: UPPER DEFLECTOR | Part Number: 647.4610 |
| Inspection Dwg: 647.4600 Rev: N/C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---|------------------|--------|--------|----------------------|----------|
| .130X45° | $\pm .005 \times \pm \frac{1}{2}^\circ$ | .130X45° | — | | Vern | ML-06 |
| .700 | $\pm .005$ | .698 | — | | " | |
| .340 | $\pm .005$ | .340 | — | | " | |
| .040X45° | $\pm .005 \times \pm \frac{1}{2}^\circ$ | .043X45° | — | | " | |
| 9.767 | $\pm .005$ | 9.767 | — | | H-G | 31006 |
| 9.060 | $\pm .005$ | 9.060 | — | | " | |
| 3.543 | $\pm .005$ | 3.543 | — | | " | |
| .326 | $\pm .005$ | .326 | — | | " | |
| .380 | $\pm .005$ | .375 | — | | Vern | ML-06 |
| 9.932 | $\pm .005$ | 9.934 | — | | H-G | 31006 |
| Ø.206 | $\pm .005$ | Ø.206 | — | | Vern | ML-06 |
| Ø.177 | $\pm .005$ | Ø.177 | — | | " | |
| .300X23.0° | $\pm .005 \times \pm \frac{1}{2}^\circ$ | .300X23.0° | | | " | |
| 4.220 | $\pm .002$ | 4.220 | — | | " | |
| 2.110 | $\pm .002$ | 2.110 | — | | " | |
| .900 | $\pm .005$ | .899 | — | | " | |
| | | | | | | |
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| | | |
|---|--------------------------------------|------------------------------|
| Measured by: <i>ml</i> ^{DAS} 14 | Audited by: ^{DAS} 25 | Preliminary Approval: |
| Date: 12/11/21 | Date: 12-11-21 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

10.04.15

| | | | | | | |
|--|--|-------------------------|------------------------|-----------------------|--|--|
| APICAL INDUSTRIES, INC. | ENGINEERING CHANGE NOTICE NO. 03088 | | | | SHEET 1 - OF 1 | |
| | DWG NO. 647.4600 | REV: N/C | PREPARED BY R. ROSANO | DATE: 04/27/11 | EFFECT. ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC. | |
| | DWG TITLE: DEFLECTORS | | | | | |
| | APPROVED BY: <i>[Signature]</i> | ENGR <i>[Signature]</i> | MFG <i>[Signature]</i> | QC <i>[Signature]</i> | EFF: NEXT ORDER | |
| TRANSACTION CODES (C) A-ADD C-CREATE R-REVISE D-DELETE | REASON: CORRECTED HOLE SIZE FOR 647.4610 UPPER DEFLECTOR, REVISED DELTA NOTE 2 | | | | | |

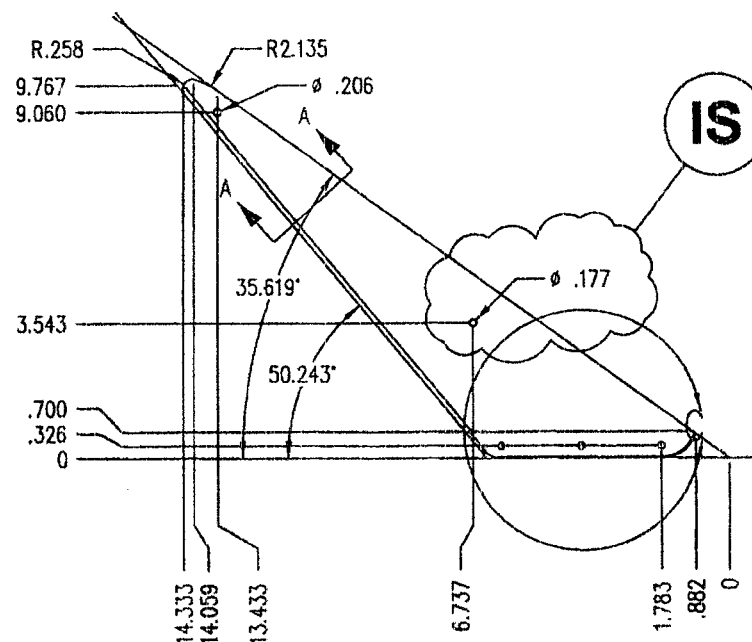
SHEET 1, ZONE A1, IS:

NOTES:

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK.
~~PRETREAT PR-148 ADHESION PROMOTER;
 PRIME IAW MIL-P-23377 TYPE I CLASS N; 1-2 MIL MAX.~~
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. MAXIMUM DIMENSION AFTER FINISH

IS

SHEET 1, ZONE C3, IS:



| | | | | | | |
|---------------------|----|-------------|-----|---|---|--|
| F/N | TC | PART NUMBER | QTY | DESCRIPTION | MATERIAL | SPECIFICATION |
| DOCUMENTS EFFECTED: | | | | <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input type="checkbox"/> BOM | CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR | DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO |

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NOTES:

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. MAXIMUM DIMENSION AFTER FINISH

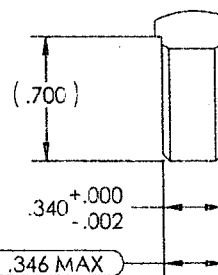
UNINCORPORATED ECN(S)

03088

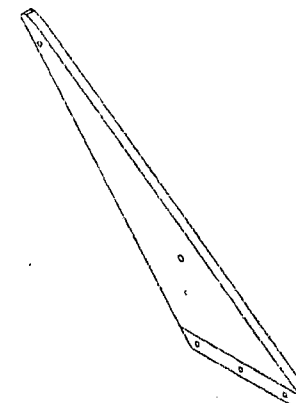
| REVISIONS | | | |
|-----------|-----------------|---------|-----------|
| REV | DESCRIPTION | DATE | APPROVED |
| 1 | LAST PROTOTYPED | 10-1-07 | N/C |
| 2 | REVAL RELEASE | 10-1-07 | P. BAYARD |

.130 X 45.0° TYP

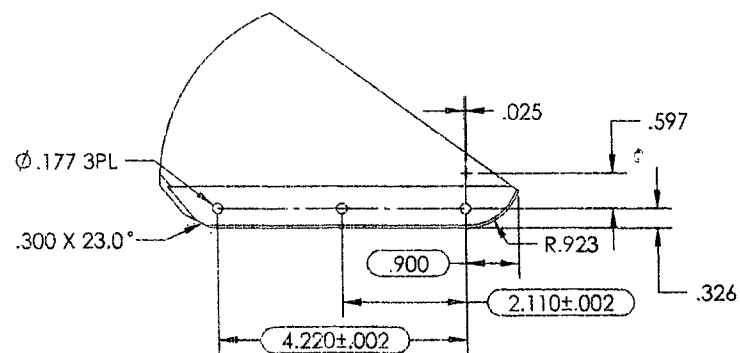
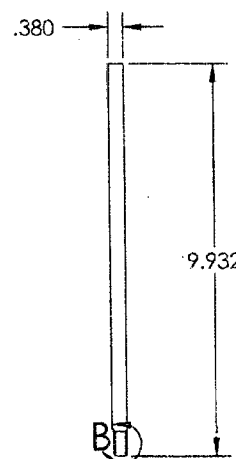
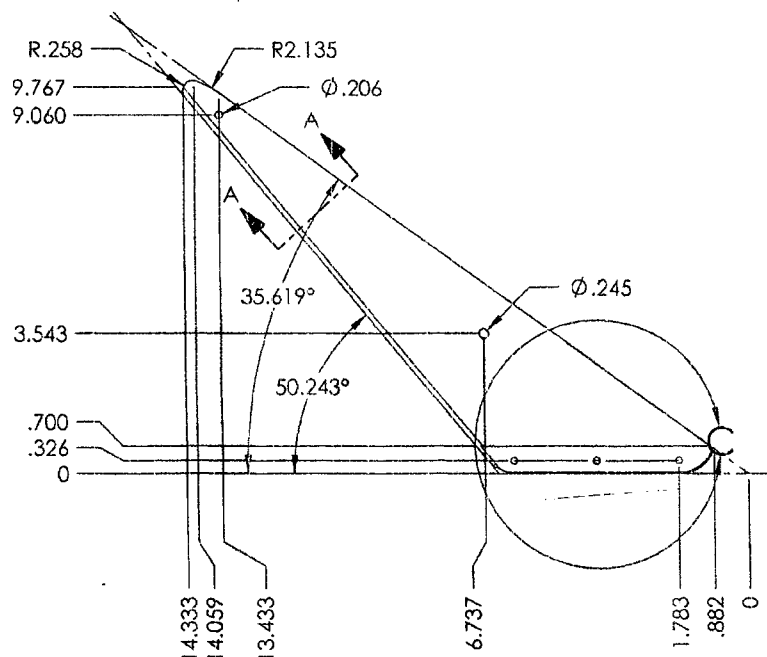
SECTION A-A



DETAIL B



647.4610

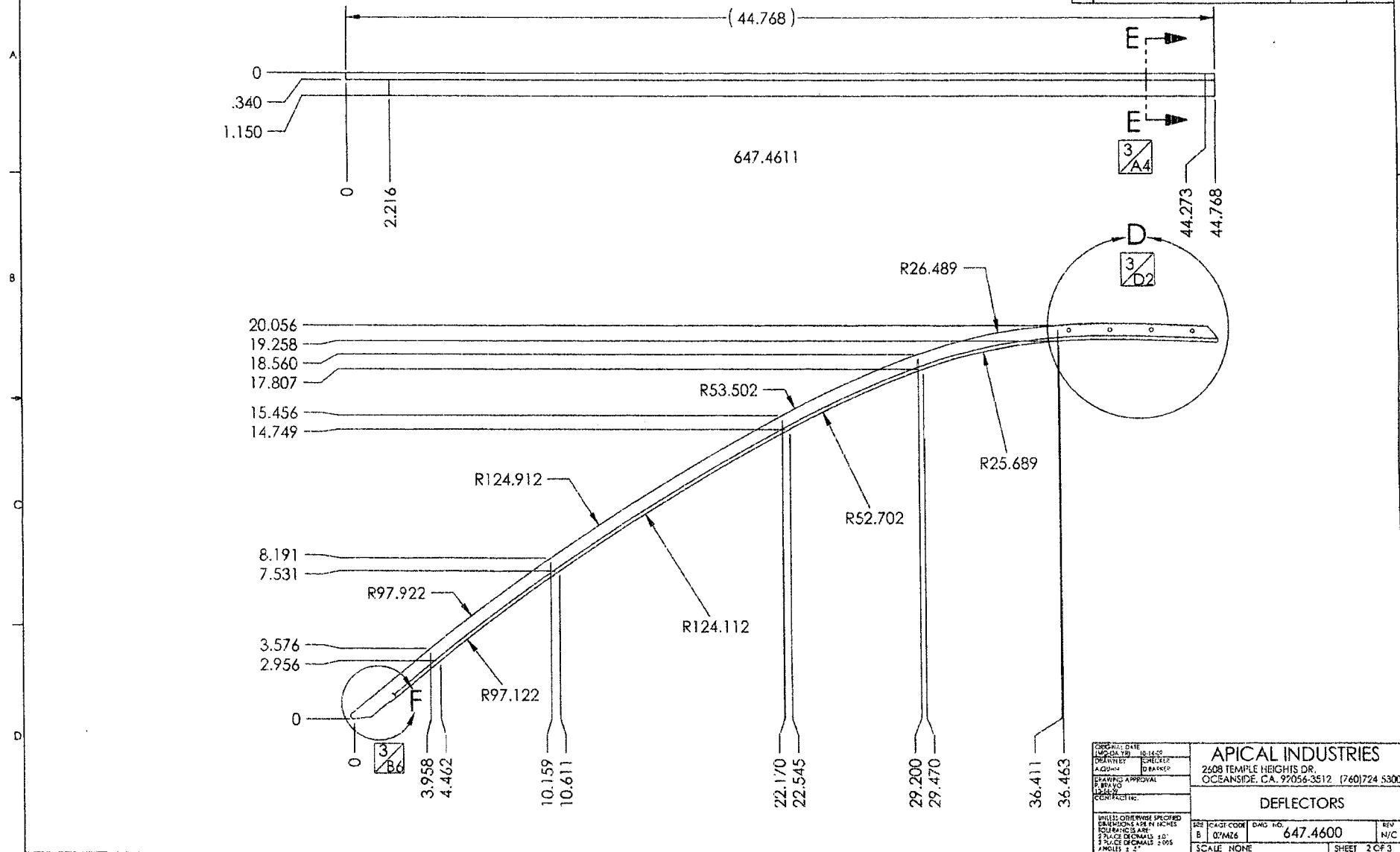


DETAIL C

| | | | | | |
|---|---|----------|---|------|-------|
| | | 647.4611 | DEFLECTOR | | |
| | 1 | 647.4610 | UPPER DEFLECTOR | | |
| | | PART # | DESCRIPTION | MATL | SPEC. |
| QTY | | | PARTS LIST | | |
| NEXT ASSY (S) | | | APICAL INDUSTRIES | | |
| 647.2600 | | | 2508 TEMPLE HEIGHTS DR. | | |
| 647.4500 | | | OCEANSIDE, CA. 92056-3512 (760)724-5300 | | |
| ORIGINAL DATE MODIFIED BY A. COLLINS DRAWN BY D. BARKER CHECKED BY J. BARKER DATE 10/1/83 REVISIONS REWORKING A PROPOSED DESIGN CONTRACTING | | | DEFLECTORS | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS ±.01 3 PLACES DECIMALS ±.005 ANGLES 1° | | | DATE B 07/26/84 DWG NO 647.4600 SCALE NONE SHEET 1 OF 3 | | |

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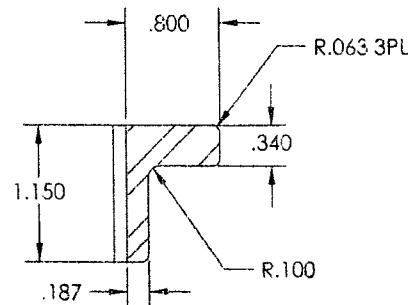
| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV. | DESCRIPTION | DATE | APPROVED |
| | | | |
| | | | |



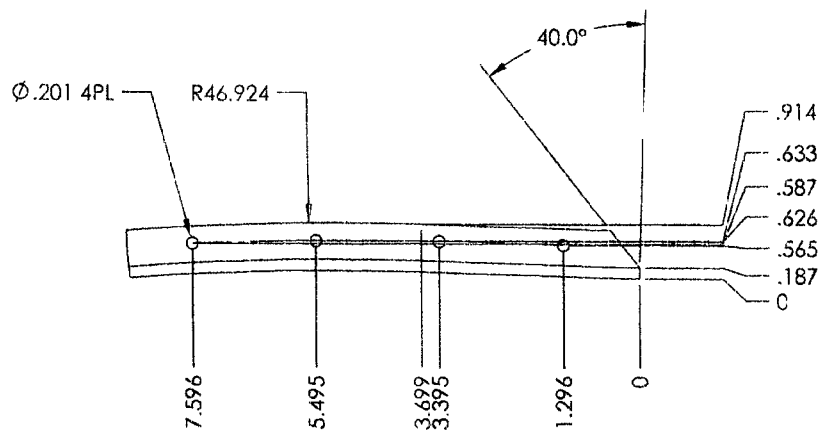
| | | | |
|----------------------------|--|---|--|
| ORIGINAL DATE: 10-14-02 | | APICAL INDUSTRIES | |
| QUANTITY: 1000 | | 2608 TEMPLE HEIGHTS DR. | |
| ACQUANT: 1000 | | OCEANSIDE, CA. 92056-3512 (760)724 5300 | |
| DRAWING APPROVAL: 10-14-02 | | DEFLECTORS | |
| CONTRACTING: | | | |
| UNLESS OTHERWISE SPECIFIED | | SCALE: NONE | |
| DIMENSIONS ARE IN INCHES | | SHEET 2 OF 3 | |
| TOLERANCES ARE: | | | |
| 3 PLACE DECIMALS ±.01 | | | |
| 3 PLACE DECIMALS ±.005 | | | |
| ANGLES ±.2° | | | |

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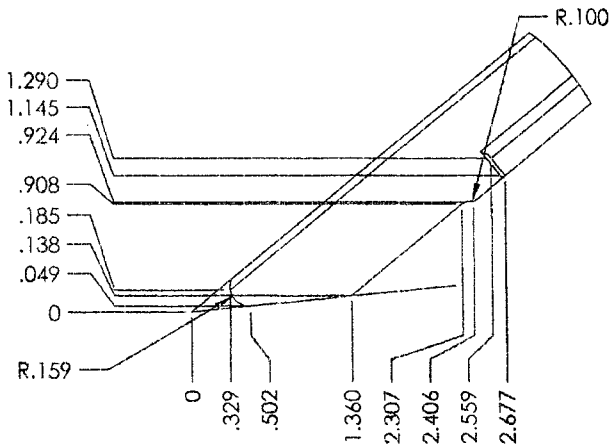
| REVISIONS | | | |
|-----------|-------------|------|----------|
| REV | DESCRIPTION | DATE | APPROVED |
| | | | |
| | | | |



SECTION E-E 2/A7



DETAIL D 2/87



DETAIL F 2/D2

| | | | |
|--|--|--|--------------|
| DESIGNED BY: DRAWN BY: CHECKED BY: DATE: 10-14-07 | | APICAL INDUSTRIES 2608 TEMPLE HEIGHT'S DR. OCEANSIDE, CA 92056-3512 (760)724-5300 | |
| DRAWING APPROVAL BY: DATE: CONTRACT NO: | | DEFLECTORS | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 ANGLES ± .5° | | SCALE: NONE | SHEET 3 OF 3 |



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62107

Date: 12-Dec-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

| Terms | Ship Via |
|---|--|
| Quantity | Description |
| 1 lot | Part: ASST Rev: |
| | 8 PCS 647.1610 5 PCS 647.1612 2 PCS 647.1713 6 PCS 647.1811 1 PC 647.1816 1 PC 647.1817 8 PCS 647.1818 11 PCS 646.3210 20 PCS 646.3313 10 PCS 646.3717 20 PCS 646.3717 16 PCS 647.4610 10 PCS 649.4811 10 PCS 649.4812 24 PCS 649.4814 30 PCS 649.4815 6 PCS 647.7913 3 PCS 647.7919 10 PCS 647.9010 10 PCS 647.9011 15 PCS 647.9012 40 PCS 647.9013 60 PCS 646.9710 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120768 |
| PO: PO18506 | |
| Line: | |
| Certificate of Conformance | |
| A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. | |
| ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY | |
| DATE: 12/12/12 | |



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62107

Date: 12-Dec-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


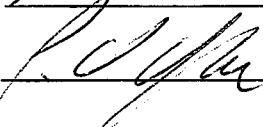
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

| Terms | Ship Via |
|----------|---|
| | |
| Quantity | Description |
| | CERTIFIED SIGNATURE :  |
| | RECEIVER SIGNATURE :  |